

Date: Monday, 2/12/2007 4:15:12 PM  
User: Linda Lacelle

## **Process Sheet**

|  |   |   |                  |                 |  |
|--|---|---|------------------|-----------------|--|
| Customer   | : CU-DAR001 Dart Helicopters Services   |   | Drawing Name     | : DOOR ASSEMBLY |  |
| Job Number   | : 30657   |   |                  |                 |  |
| Estimate Number  | : 10712   |   |                  |                 |  |
| P.O. Number  | : N/A   |   | Part Number      | : D32133        |  |
| This Issue   | : 2/12/2007   | S.O. No. : N/A  | Drawing Number   | : D3213 REV A   |  |
| Prsht Rev.   | : NC  |   | Project Number   | : N/A           |  |
| First Issue  | : N/A   |   | Drawing Revision | : A             |  |
| Previous Run   | : 30657   |   | Material         | : N/A           |  |
| Written By   |   |   | Due Date         | : 2/19/2007     |  |
| Checked & Approved By  |   |   | Qty:             | 8 Um: Each      |  |
| Comment  | : Est Rev:A New Issue 05-11-17 JLM<br>Est Rev:B Now on Waterjet 07-02-13 JLM      |   |                  |                 |  |
| <b>Additional Product</b>  |   |   |                  |                 |  |
| Job Number:  |  |   |                  |                 |  |
| Seq. #:  | Machine Or Operation:   | Description :   |                  |                 |  |
| 1.0  | M2024T3S063   | 2024-T3 .063 sheet                         |                  |                 |  |
| Comment: Qty.: 0.4950 sf(s)/Unit Total: 3.9598 sf(s)<br>Material: 2024-T3 (QQ-A-250/4) 0.063" thick<br>(M2024T3S.063) Identify as D3213-3<br>Batch: <del>1102942</del> 1102942 |   |   |                  |                 |  |
| 2.0  | WATER JET   | FLOW WATER JET                           |                  |                 |  |
| Comment: FLOW WATER JET <span style="float: right;">SAD 07/02/18</span>  |   |   |                  |                 |  |
| 3.0  | QC2   | INSPECT PARTS AS THEY COME OFF MACHINE   |                  |                 |  |
| Comment: INSPECT PARTS AS THEY COME OFF MACHINE <span style="float: right;">SAD 07/02/18</span>  |   |   |                  |                 |  |
| 4.0  | QC8   | SECOND CHECK <br><i>2024-19-B</i>        |                  |                 |  |
| Comment: SECOND CHECK  |   |   |                  |                 |  |
| 5.0  | SMALL FAB 1   | SMALL & MEDIUM FAB RESOURCE 1            |                  |                 |  |
| Comment: SMALL & MEDIUM FAB RESOURCE 1<br>Deburr <span style="float: right;">ml 07/02/20</span>  |   |   |                  |                 |  |
| 6.0  | HAND FINISHING1   | HAND FINISHING RESOURCE #1 <br><i>8X</i> |                  |                 |  |
| Comment: HAND FINISHING RESOURCE #1<br>Chemical Conversion Coat as per QSI 005 4.1 <span style="float: right;">07/02/20</span>   |   |   |                  |                 |  |

| W/O: |      | WORK ORDER CHANGES |  |  |    |      |     |                                     |                          |
|------|------|--------------------|--|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   |  |  | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |  |  |    |      |     |                                     |                          |
|      |      |                    |  |  |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/02/23  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Monday, 2/12/2007 4:15:12 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 30657

Part Number: D32133

Job Number:



Seq. #: Machine Or Operation:

Description :

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



X8

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

ml 07/02/20

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

5792

07/21(4)

ml 07/02/20 X4

(4)

9.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/21(4)  
Dart 2023

Job Completion



U 07/02/23

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Monday, 2/5/2007 4:02:56 PM.  
 User: Kim Johnston

## Process Sheet

|                       |                                       |            |                  |                 |      |            |
|-----------------------|---------------------------------------|------------|------------------|-----------------|------|------------|
| Customer              | : CU-DAR001 Dart Helicopters Services |            | Drawing Name     | : DOOR ASSEMBLY |      |            |
| Job Number            | : 30657                               |            | Part Number      | : D32133        |      |            |
| Estimate Number       | : 10712                               |            | Drawing Number   | : D3213 REV A   |      |            |
| P.O. Number           | :                                     |            | Project Number   | : N/A           |      |            |
| This Issue            | : 2/5/2007                            | S.O. No. : | Drawing Revision | : A             |      |            |
| Prsh Rev.             | : NC                                  |            | Material         | :               |      |            |
| First Issue           | : 2/5/2007                            | Type       | : MACHINED PARTS |                 |      |            |
| Previous Run          | : 25261                               |            | Due Date         | : 2/23/2007     | Qty: | 8 Um: Each |
| Written By            | :                                     |            |                  |                 |      |            |
| Checked & Approved By | :                                     |            |                  |                 |      |            |
| Comment               | : Est Rev:A                           |            | New Issue        | 05-11-17        | JLM  |            |

## Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description :  |
|---------|-----------------------|--|
| 1.0     | M2024T3S063           | 2024-T3 .063 sheet<br>   |
|         |                       | Comment: Qty.: 0.4950 sf(s)/Unit Total : 3.9598 sf(s)<br>Material: 2024-T3 (QQ-A-250/4) 0.063" thick<br>(M2024T3S.063) identify as D3213-3<br>Batch: _____ |
| 2.0     | SHEAR                 | <br>Comment: SHEAR<br>Cut blanks: 15.100" x 4.500" (+0.000/-0.010)   |
| 3.0     | HAAS1                 | HAAS CNC VERTICAL MACHINING #1<br>   |
|         |                       | Comment: HAAS CNC VERTICAL MACHINING #1<br><br>1-Machine D3213-1 as per Folio FA350 and Dwg D3213<br>Stack of 4  |
| 4.0     | QC2                   | INSPECT PARTS AS THEY COME OFF MACHINE<br>   |
|         |                       | Comment: INSPECT PARTS AS THEY COME OFF MACHINE  |
| 5.0     | QC8                   | SECOND CHECK<br>   |
|         |                       | Comment: SECOND CHECK  |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Monday, 2/5/2007 4:02:56 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 30657

Part Number: D32133

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

|                         |              |             |
|-------------------------|--------------|-------------|
| DART AEROSPACE LTD      | Work Order:  | 30657       |
| Description: Door Panel | Part Number: | D3213-3     |
| Inspection Dwg: D3213   | Rev: A       | Page 1 of 1 |

# FIRST ARTICLE INSPECTION CHECKLIST

X First Article | Prototype

|              |                 |             |                 |                     |     |
|--------------|-----------------|-------------|-----------------|---------------------|-----|
| Measured by: | <u>SAM</u>      | Audited by: | <u>J.L.</u>     | Prototype Approval: | N/A |
| Date:        | <u>07/02/18</u> | Date:       | <u>07/02/18</u> | Date:               | N/A |

| Rev | Date     | Change                                 | Revised by | Approved |
|-----|----------|--|------------|----------|
| A   | 03.12.15 | New Issue P/O D350-567-015/-025/-031   | KJ/RF      |          |
| B   | 04.06.15 | Tolerance changed for 14.400 dimension | KJ/JLM     |          |

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WORK ORDER  
3065

RETURN TO ENGINEER

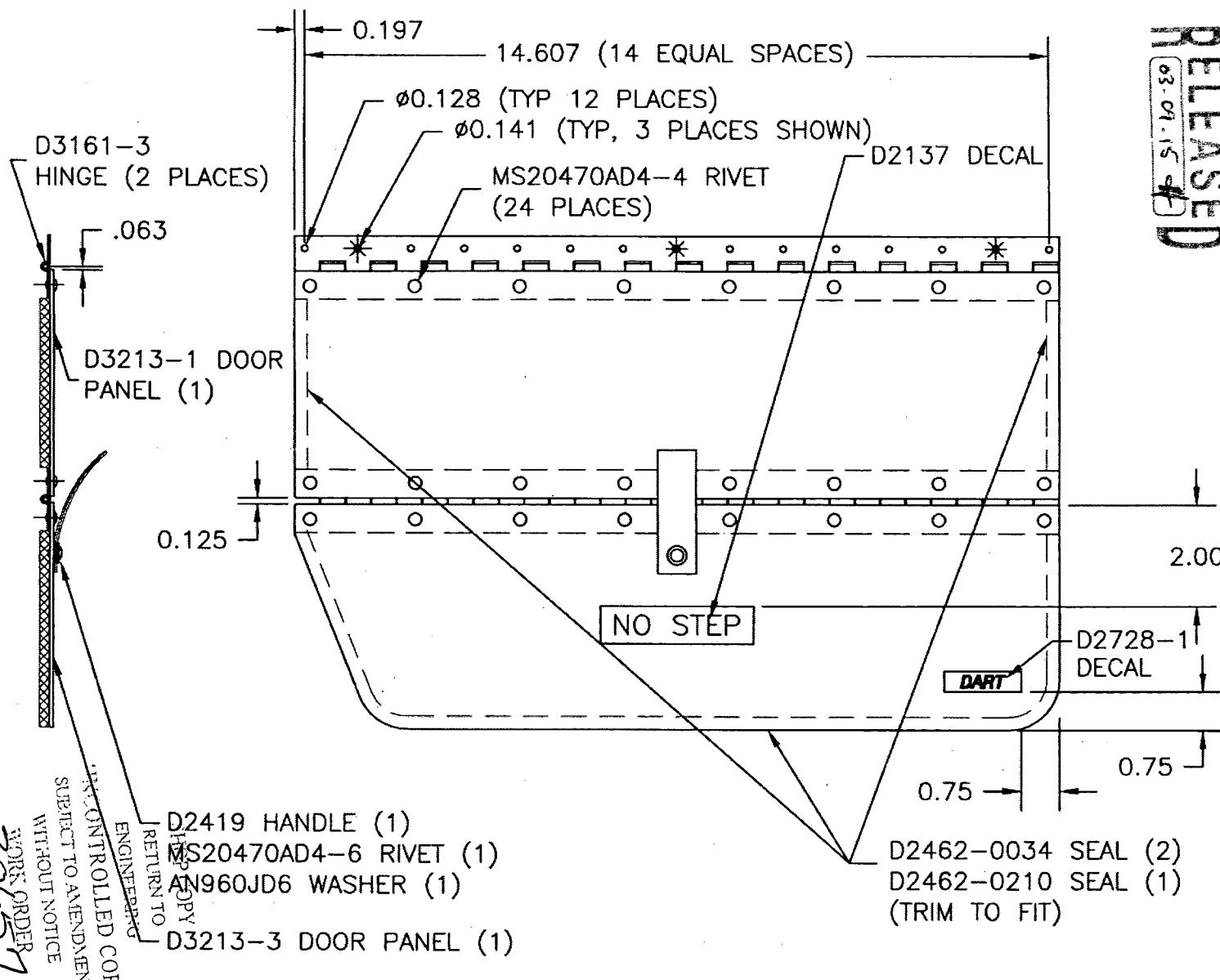
UNCONTROLLED COPY

HIS COPY

RETURN TO ENGINEER

SUBJECT TO AMENDMENT

WITHOUT NOTICE



### D3213-041 DOOR ASSEMBLY

FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE

FINISH: POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3

INSTALL D2137 DECAL, D2419 HANDLE, AND D2462 SEAL AFTER POWDER COAT

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED  
03.01.15

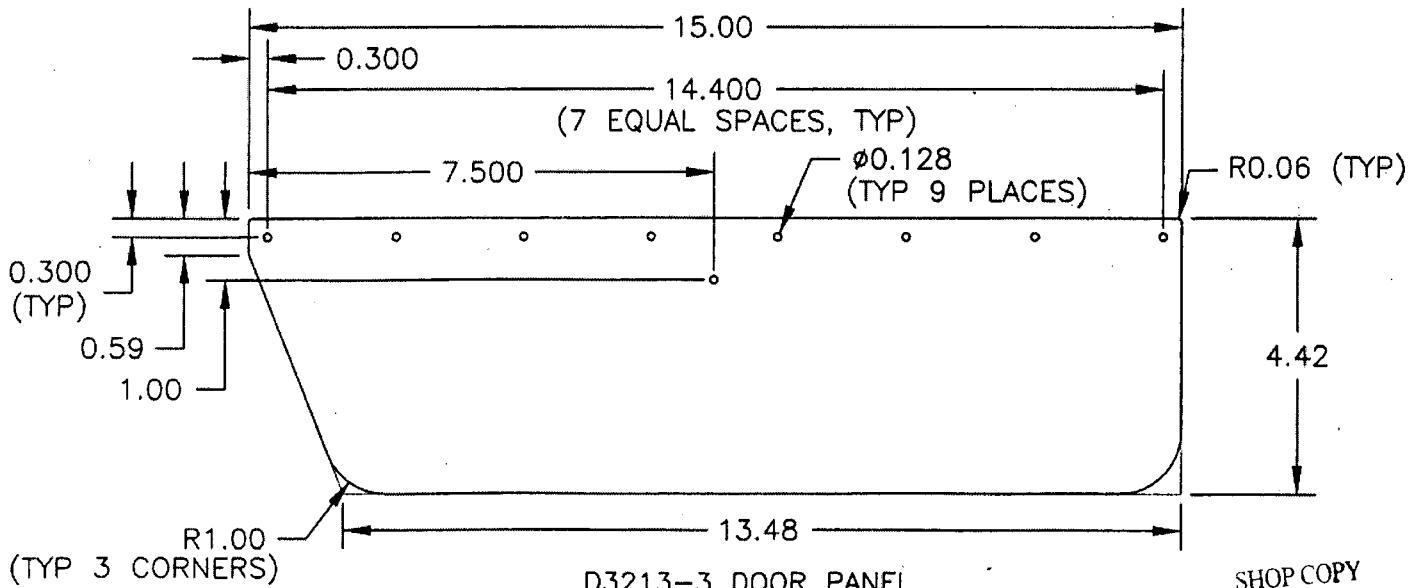
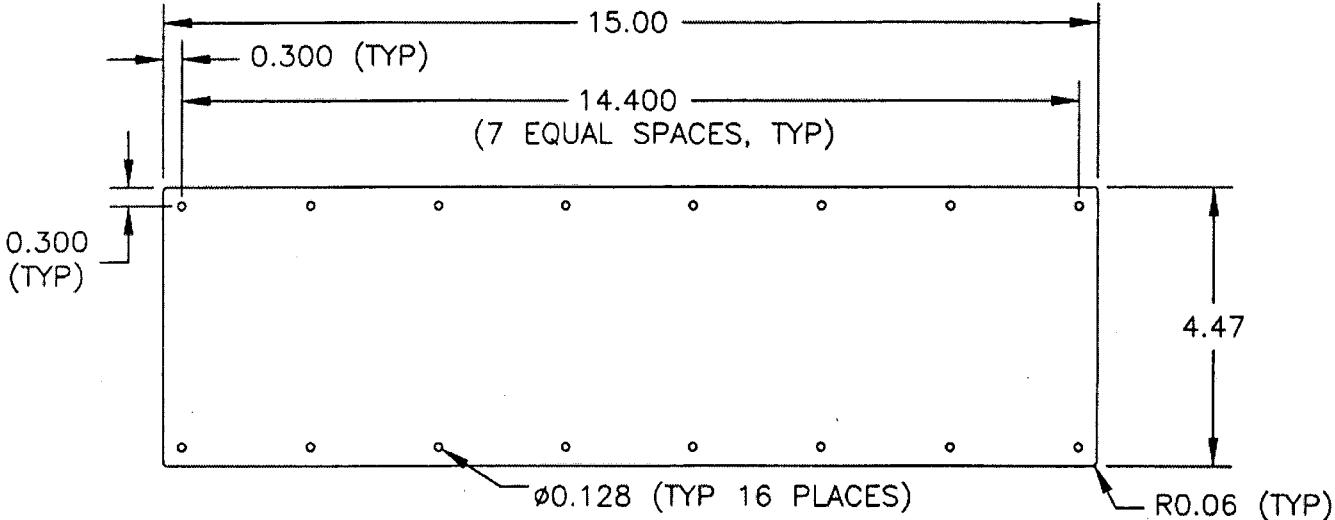
**DART**

ACOPY  
SUEDE

|         |          |             |               |                             |
|---------|----------|-------------|---------------|-----------------------------|
| DESIGN  | A        | DRAWN BY    | CJ            | DART AEROSPACE LTD          |
| CHANGED |          | APPROVED    |               | HAWKESBURY, ONTARIO, CANADA |
| DATE    | 03.09.03 | DRAWING NO. | D3213         | REV. A                      |
|         |          | TITLE       | DOOR ASSEMBLY | 1 OF 2                      |
| A       | 03.09.03 | SCALE       |               | 1:3                         |

**DART**

|                  |                        |  |
|------------------|------------------------|--|
| DESIGN           | DRAWN BY               | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |
| CHECKED          | APPROVED               | DRAWING NO.<br>D3213                                     |
| DATE<br>03.09.03 | TITLE<br>DOOR ASSEMBLY | REV. A<br>2 OF 2<br>SCALE<br>1:3                         |

D3213-1 AND D3213-3

MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**RELEASED**  
03.09.03  
AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 30657

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